

Date: Tuesday, 04/07/2006 12:35:21 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEAR PLATE
Job Number : 27736	
Estimate Number : 11231	
P.O. Number : N/A	Part Number : D2348
This Issue : 04/07/2006 S.O. No. : N/A	Drawing Number : D2348 REV B2
Prsht Rev. : NC	Project Number : N/A
First Issue : 28/06/2006 Type : MACHINED PARTS	Drawing Revision : A
Previous Run :	Material : N/A
Written By : _____	Due Date : 22/07/2006 Qty: 50 Um: Each
Checked & Approved By : _____	
Comment : Est Rev A Removed from 9 Digit 05-12-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0208 sf(s)/Unit Total : 1.0395 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Batch: 118556

06 07 11

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

06 07 11

50

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06 07 11

50

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

06 07 20 50

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

SAD 06 07 26

50

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

06 07 26 50

Date: Tuesday, 04/07/2006 12:35:21 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 27736

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING

Issue P/O: 1797

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

C206/08/09

50

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AL 06/08/15 50

PTO

10.0

FE832EF

PEM Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 FE832EF PEM Insert M101483

M101634

34

90

SB 06/08/17 49

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2348

SB 06/08/17 46

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-23 46

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 3140

AL 06/08/23 46

Date: Tuesday, 04/07/2006 12:35:21 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 27736

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21


A 06.08.24

Job Completion



U 06.08.23

PTO →

Date	Step	Procedure Change	by	date	Qty	Approval	QC
06-08-16	9.1	Add QC 5 to inspect certs: work. Perm. Change. QCS	E	06-08-16			 06-08-16

Date: Wednesday, 6/28/2006 4:17:20 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEAR PLATE
Job Number :	27736		
Estimate Number :	11231		
P.O. Number :		Part Number :	D2348
This Issue :	6/28/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2348 REV B2
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	7/22/2006
Written By :		Qty:	50
Checked & Approved By :		Um:	Each
Comment :	Est Rev A Removed from 9 Digit 05-12-05 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0208 sf(s)/Unit Total : 1.0395 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick

(M6061T6S.063)

Batch: M18556

M 06 07 11

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

cut blanks: 1.360" X 2.100"

N/A.

(PTC) →

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D2348 as per Folio FA134 and Dwg D2348

Water Jet
Dwg Rev B2
Mg Rev B2

M 06 07 11 (50)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 07 11

(50)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: <u>See ncr 080</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/08/17	7	46 part came back from Black Anodize 4 part were missing	AA	Qty 46. Contact sub-contractor to inform them of missing parts. No response	W 06/08/23		N/A	

Part No: D2348 PAR #: N/A Fault Category: Supplier NCR: Yes No DQA: AA Date: 06.08.24
 NOTE: Date & initial all entries QA: N/C Closed: AA Date: 06.08.24

Date: Wednesday, 6/28/2006 4:17:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 27736

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING
Issue P/O: _____
Black Anodize per Dwg D2348
Ensure Certificate of Conformity is attached

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

FE832EF

PEM Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 200.0000 Each(s)
Pick:
Qty Part Number Description Batch
4 FE832EF PEM Insert _____

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Install Insert as per Dwg D2348

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:17:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 27736

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

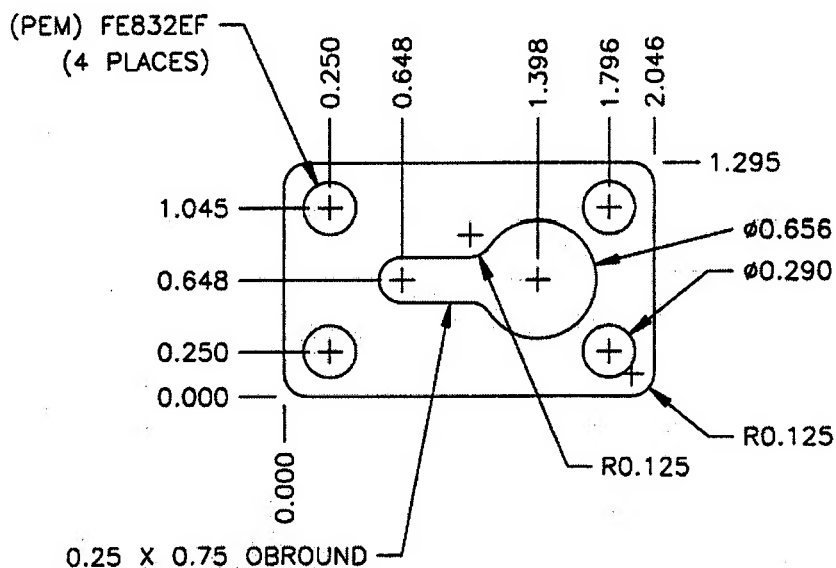
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
BW	[Signature]	D2348	SHEET 1 OF 1
DATE	TITLE		SCALE
95:01:20	WEAR PLATE		1:1
B	95:02:20	CHANGED PEM INSERT TO 8-32	
B1	00.03.07	CHANGE TO AISI 304/316 MATERIAL	
B2	02.02.21	CHANGE BACK TO 6061-T6	

RELEASED
97/04/22 DS



- NOTES:
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 (M6061T6S)
 - 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/III/IV CLASS 2
 - 3) INSTALL FE832EF INSERTS AFTER ANODIZING
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER PART QSF 01B UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27736

~~AISI 304/316 SS~~

~~MATERIAL: 6061-T6 ALUMINUM 0.063 THICK; ANODIZE BLACK
AFTER ANODIZING INSTALL (PEM FE832EF) 4 PLACES~~

DART AEROSPACE LTD		Work Order:	27736
Description:		Part Number:	2348
Inspection Dwg:	Rev:	Page 1 of 1	


FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

Measured by:	<i>ml. ml</i>
Date:	<i>06 07 12</i>

Audited by:	
Date:	06-07-20

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

49229

14-Aug-2006

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****PURCHASE ORDER/
NO. DE COMMANDE:**

00001797



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	50	50	D2348 WEARPLATE	BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager ☐ ☐